DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-004990
Date Inspected: 13-Dec-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 630
OSM Departure Time: 1430
Location: Shanghai, China

CWI Name:	Sun Wei / Sun Bo	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☑ Yes ☐ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower Components

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 1 – New Tower Shop

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Flux Core Arc Welding (FCAW) of weld joints connecting longitudinal stiffener plates to skin plate NSD1-Skin B-Lift 1. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Flux Core Arc Welding (FCAW) of weld joints connecting longitudinal stiffener plates to skin plate NSD1-Skin E-Lift 1. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld joints connecting longitudinal stiffener plates to skin plate NSD1-Skin A-Lift 1. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Bay 2 – New Tower Shop

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld joints on connection plates WSD1-SA218-2A. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld joints on connection plates WSD1-SA99-2A. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld joints connecting longitudinal stiffener plates to skin plate WSD1-Skin A-Lift 1. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) weld joints connecting longitudinal stiffener plates to skin plate WSD1-Skin B-Lift 1. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Tracking and Log Book

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer